

Work Order ID **76291*****76291***

Page 1

Tuesday, November 08, 2011 1:34:23 PM

Item ID: D3912-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Eyebolt Receiver Assembly

Start Date: 11/8/2011 Start Qty: 6.00

Required Date: 11/22/2011 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: M.L.JDate: 11/11/08

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3912

B

100

Pick Kit

0.00

100

Packaging

Memo

0.00

Packaging

110

0.00

110

Small Fab

Memo

0.00

Small Fab

1-Assemble D3912-1/-3/-5 and install rivets as per dwg
TRIM RIVETS 1.250" LONG

2- Install helical, spring plunger and spring pin lanyard assy as per dwg

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

Sub 12/12

③

③ 11/12/12

③ 11/12/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Item ID: D3912-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Eyebolt Receiver Assembly

Start Date: 11/8/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 11/22/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>507</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

11/12/13

mf
11-12-13

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Picklist Print

Tuesday, November 08, 2011 1:34:29 PM

Page 1

Work Order ID: 76291

76291

Parent Item: D3912-041

D3912-041

Parent Item Name: Eyebolt Receiver Assembly

Start Date: 11/8/2011

Required Date: 11/22/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: new issue DD 09.11.18 verified by:EC IPP Rev:B
10.06.10 memo in seq110 ***IF PLUNGER GOES IN TO DEEP, INSTALL A
WASHER (AN960C516L) IF NECESSARY BETWEEN PLUNGER AND
D3912-1. YOU MAY HAVE TO ENLARGE WASHER HOLE FOR IT TO
FIT*** DD verf:JLM IPP REV:C AS PER REV B 10-08-05 JLM
VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149C0663R Washer		Purchased	No				Each	218.0000					
NAS1149C0663R										**			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST297			218						
				110139			18						
				116893			200						
D3912-1 Eyebolt		Manufactured	No			100	Each	8.0000	1	6			
D3912-1										**			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST091			8						
				69593			8						
D3912-3 Eyebolt Block		Manufactured	No			100	Each	3.0000	2	12			
D3912-3										**			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST091			3						
				69539			2						
				70424			1						

B76292 (60)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Page 2

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Work Order ID: 76291

76291

Parent Item: D3912-041

D3912-041

Parent Item Name: Eyebolt Receiver Assembly

Start Date: 11/8/2011

Required Date: 11/22/2011

Start Qty: 6.00

Required Qty: 6.00

~~D3912-5~~ 1
D3912-5
Eyebolt Plate

Manufactured No

100 Each 2.0000 2 12

**

EB 11/12/12

Location Loc Qty Loc Code

ST091 2

73331 2

Each 20.0000

**

B 76293 (4x)
EB 11/12/12

Location Loc Qty Loc Code

ST083 18

75178 18

ST084 2

68379 2

100 Each 114.0000 8 48

**

EB 11/12/12

~~MS20615-4M20~~

Purchased No

MS20615-4M20
RIVET

Location Loc Qty Loc Code

GA 114

117071 30

118571 34

119546 50

Each 23.0000

**

EB 11/12/12

~~MS21209-F615~~

Purchased No

MS21209-F615
Heli-Coil

Location Loc Qty Loc Code

ST304 23

108170 14

108244 9

Tuesday, November 08, 2011 1:34:29 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

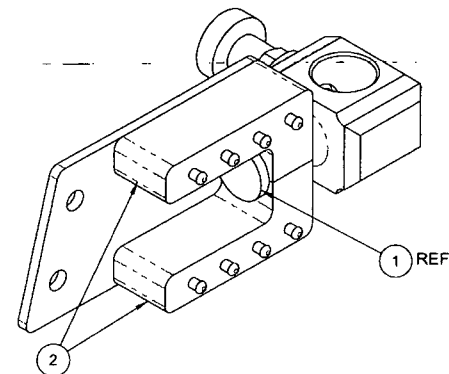
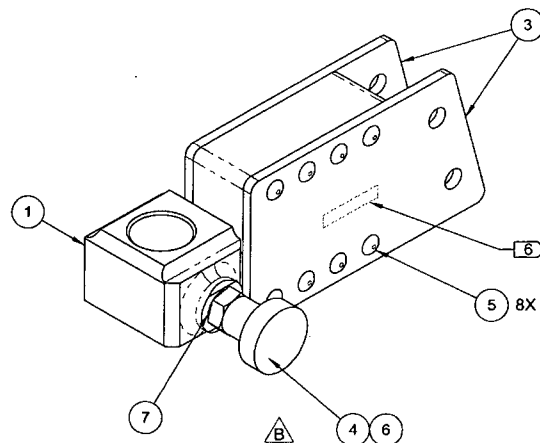
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ITEM	QTY	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

TOP COPY
TURN TO
ENGINEERING
UNCO: ROLLED COPY
SUBJ: TO AMENDMENT
V: OUT NOTICE
V: RK ORDER
NO: 76291 M.C.J.
11/12/05

D3912-041 EYEBOLT RECEIVER ASSY

- NOTES:**
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -041: 1.58 lbs

RELEASED
2010-07-16

B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0863R ADDED; BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>ALS</i>		
DRAWN	<i>ALS</i>		
CHECKED	<i>ALS</i>		
MFG. APPR.	<i>ALS</i>		
APPROVED	<i>ALS</i>		
DE APPR.	<i>ALS</i>		
DATE	10.06.28		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3912	REV. B
TITLE EYEBOLT RECEIVER ASSY	SCALE NTS

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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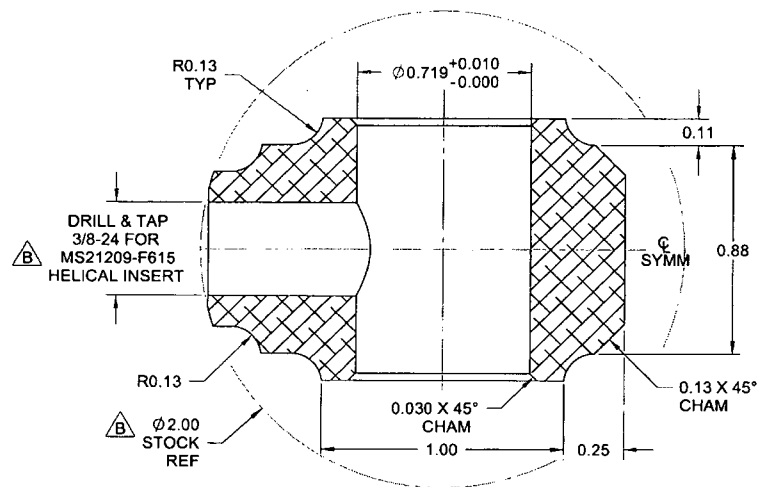
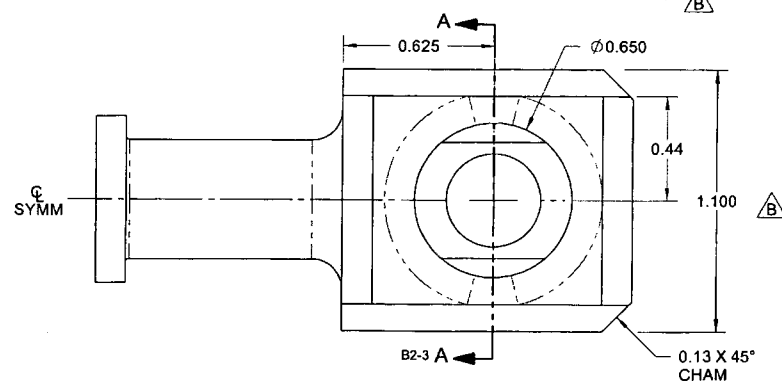
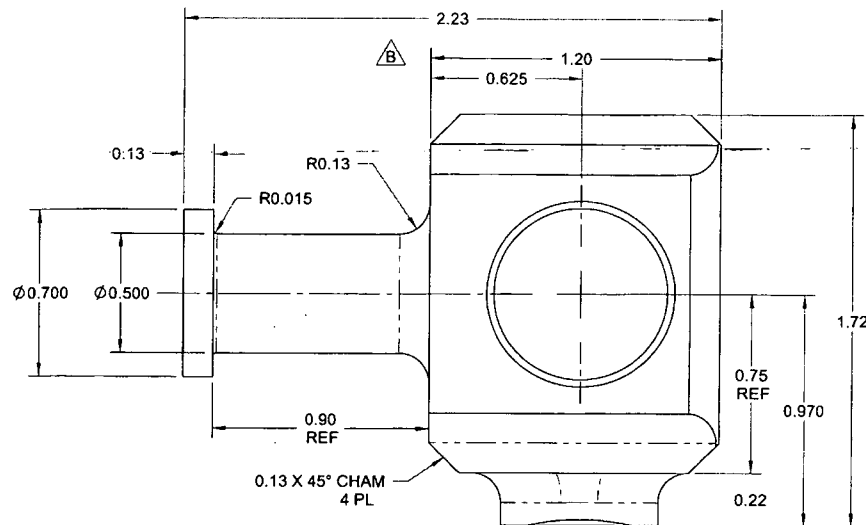
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NOTE: Date & initial all entries

76291



SECTION A-A B6-3

RELEASED
2010-07-16

D3912-1 EYEBOLT

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ID AT ASSEMBLY
 - 7) WEIGHT: 0.45 lbs

DESIGN	AS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JL	DRAWING NO.	REV. B
CHECKED	JS	D3912	SHEET 2 OF 3
MFG. APPR.	JS	TITLE	SCALE
APPROVED	JS	EYEBOLT RECEIVER ASSY	NTS
DE APPR.	JS	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.06.28		

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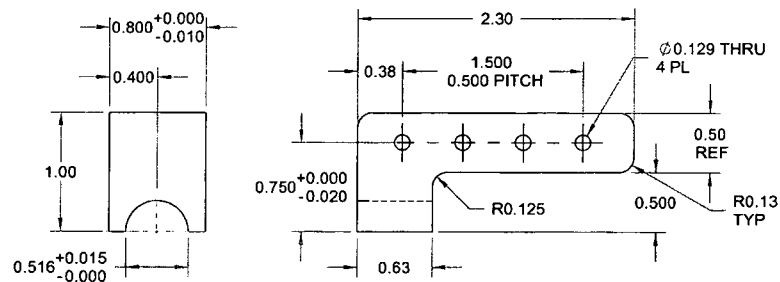
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

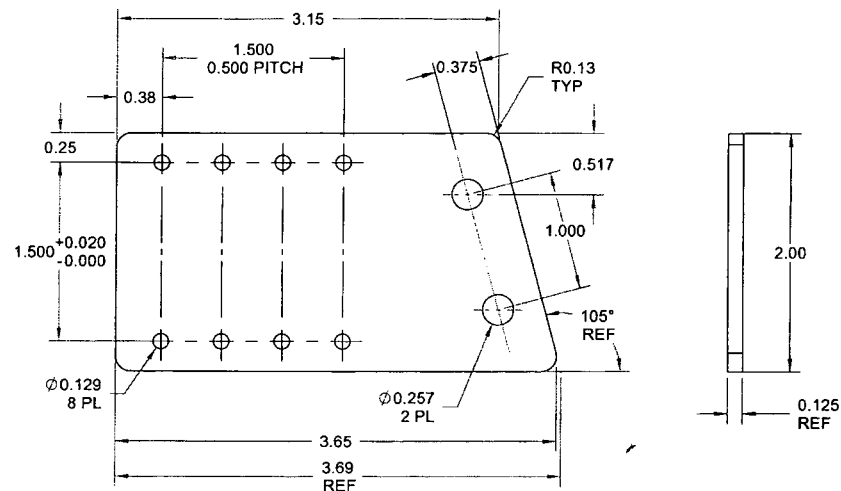
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76291



D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240 REF DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

RELEASED
2010-07-16
and

DESIGN	455	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>	DRAWING NO.	REV. B
CHECKED	<i>[Signature]</i>	D3912	SHEET 3 OF 3
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	EYEBOLT RECEIVER ASSY	NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
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